

Work Order ID 142399

Tuesday, March 08, 2016 2:20:16 PM

142399

Page 1

Item ID: PB67-43001-19

Revision ID:

Item Name: Inner Tube And Retainer Bushing

Start Date: 4/1/2016 Start Qty: 5.00

Required Date: 4/22/2016 Req'd Qty: 5.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: unf

Date: 16-3-8

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

B67-43001-19

C

100

Weld per dwg A/R Aluminum rod Batch: 130855 0.00

Large Fab

100

Large Fab

Memo

0.01

Large Fab

1- assemble and weld per dwg

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

120

QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo

0.00

Quality Control

6 MAY 30 2016 DAS 24 9-89

6 16-05-31 DAS 9 9-89

6 16-05-31 DAS 9 9-89

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Item ID: PB67-43001-19

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Inner Tube And Retainer Bushing

Start Date: 4/1/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 4/22/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish
Hand Finishing

Memo

0.02

6

JUN 14 2016

DAS
24
9-89

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC
Quality Control

Memo

0.00

6

JUN 14 2016

DAS
24
9-89

150

Identify as per dwg & Stock Location: MEZZ2

0.00

150

Packaging
Packaging

Memo

0.00

6

JUN 14 2016

DAS
24
9-89

1871

1872

1873

1874

1875

1876

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Item ID: PB67-43001-19

Accept

N900040100

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Revision ID:

Stop *NS2*

Item Name: Inner Tube And Retainer Bushing

Start Date: 4/1/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 4/22/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.01

Quality Control

JUN 14 2016

MS

JUN 14 2016

MS

1905

1905

Picklist Print

Page 1

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Parent Item: PB67-43001-19

PB67-43001-19

Parent Item Name: Inner Tube And Retainer Bushing

Start Date: 4/1/2016

Required Date: 4/22/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
10.09.28 per rev C dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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PB67-43001-287

Manufactured

No

100

Each

1.0000

1

5

**

MAY 30 2016

DAS
24
9-00***PB67-43001-287***

Inner Tube Guide, Blade Positioner

LocationLoc QtyLoc Code

Mezz2

1

141974

1

PB67-43001-295

Manufactured

No

100

Each

1.0000

1

5

**

MAY 30 2016

DAS
24
9-00***PB67-43001-295***

Extension Tube, Blade Positioner

LocationLoc QtyLoc Code

Mezz2

1

141975

1

240
PS
00-2

240
PS
00-2

240
PS
00-2

ITEM	QTY -19	P/N	DESCRIPTION
1	X	B67-43001-19	INNER TUBE AND RETAINER BUSHING
3	1	B67-43001-295	EXTENSION TUBE, BLADE POSITIONER
4	1	B67-43001-287	INNER TUBE GUIDE, BLADE POSITIONER

B67-43001-295
EXTENSION TUBE, BLADE POSITIONER

B67-43001-287
INNER TUBE GUIDE, BLADE POSITIONER

mf
#142399

0.50

B67-43001-19 INNER TUBE AND RETAINER BUSHING

RELEASED
2009-09-24
mf

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 13 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.25
REV.	DESCRIPTION		BY	DATE
DESIGN	R/W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>AS</i>			
CHECKED	<i>mf</i>	DRAWING NO.	REV. C	
MFG. APPR.	<i>mf</i>	B67-43001-19	SHEET 1 OF 1	
APPROVED	<i>mf</i>	TITLE	SCALE	
DE APPR.	N/A	INNER TUBE AND RETAINER BUSHING	NTS	
DATE	09.06.25		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.21 lbs
 - 8) WELDING: PER QSI 004

